

Work Order ID 131586

Thursday, May 07, 2015 2:00:53 PM

131586

Page 1

Item ID: D044-662-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: R44 Bearpaws

Stop ***NS2***

Start Date: 4/16/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/17/2015 Req'd Qty: 4.00

4

Customer: CALPI03

Reference: RMA RA112017

Approvals:

Process Plan: MFDate: 5-5-7

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D044-662	E								

100

0.00

100

QC

0.00

Quality Control

Memo

INSPECT RA112017

D044-662-011 X 4 (3 X B130314, 1 X B116712) PD

KITS NEED TO GO UP A CHANGE NUMBER

REMOVE FROM EACH KIT AND BRING TO GA TO SCRAP: ??

D3556-1 X 16

REMOVE AND RETURN TO STOCK UNDER ORIGINAL BATHC
NUMBER:

D2182B X 6 B

123976 x12

ADD TO KITS:

124914 x4

D3556-1 X 4 PER KIT (16 TOTAL)

D4953-1 X 4 PER KIT (16 TOTAL)

ID AND STOCK UNDER NEW BATCH NUMBER @ CHANGE 004

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 131586***131586***

Page 2

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N900040100

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

Identify as per dwg & Stock Location: **014**

0.00

110

Packaging

Memo

0.00

Packaging

4
DAS
6
989

MAY 2 1 2015

120

QC21- Final Inspection - Work Order Release

0.00

120

QC

Memo

0.00

Quality Control

MLJ

MAY 2 1 2015

MLJ
15-5-20

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 131586

131586

Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 4/16/2015

Required Date: 4/17/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C04.02.19 Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
 IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D044-662-011

Manufactured No

Each 0.0000

4

D044-662-011

R44 Bearpaws

**

1x116712, 3x130314 55-?

D2182B

Manufactured No

f 551.7680

-6

D2182B

Rubber Cushion - Black (\$Per Foot)

**

LocationLoc QtyLoc Code

DAS

ST411

201.768

6
9-89

108914

3

115189

21.5

128976

177.268

st640

350

130427

350

D3556-1

Manufactured No

Each 40.0000

16

D3556-1

Clamp For R44 Bearpaw

**

132901

DAS
6
9-89LocationLoc QtyLoc Code

ST542

40

131429

40

D4953-1

Manufactured No

Each 62.0000

16

D4953-1

Cushion

**

LocationLoc QtyLoc CodeDAS
6
9-89

ST545

62

131442

62

DAS
28
9-89DAS
28
9-89

DQA: _____ Date: _____



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OTHER : _____					

RA112017

Received @ Dart April 3, 2015
Inspected@ Dart April 15, 2015

CUSTOMER: ALPINE AIR ALASKA INC
CUSTOMER CONTACT: ELY WOODS
SHIPPED FROM: ANCHORAGE, ALASKA USA

Instructions for RA112017 D044-662-011 B130314/B116712

- 4 kits inspected and complete
- Stock under new batch number
- Add labels and paper work

Instructions for RA112017 D044-662-041 B130316

- 4 kits was sent by customer by error
- Sent back to customer

Time Estimate: 1 hour

Departments Required: quality, stores

Pictures Attached: N/A

QTY INSPECTED: 3x D044-662-011 B130314

1x D044-662-011 B116712

4x D044-662-041 B130316

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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